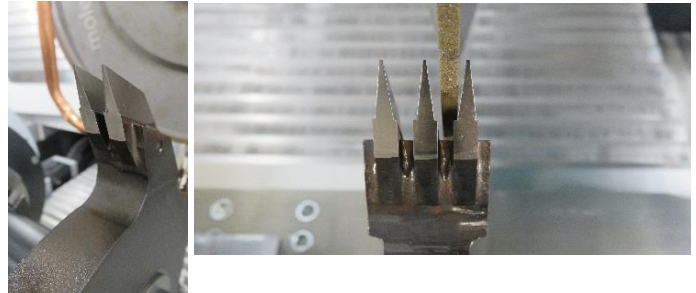
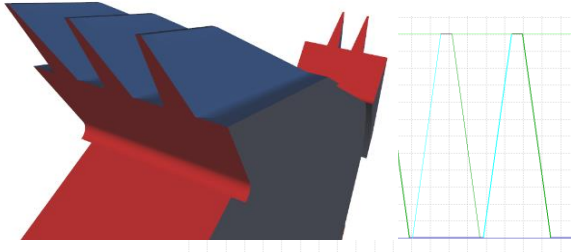
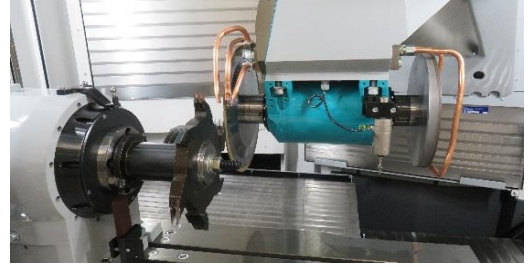















FingerJoint Cutter Ø250 Z6

A16-301

The profilepregrinding process plunge and flanks are ground with a pack of 4 1A1 wheels equally spaced according to fingerjoint-geometry. It needs one plunge per tooth to open the teeth and 2 plunges per tooth for pregrinding the flanks. Finishing is grinding all the flanks in contourgrinding with a large 1A1 wheel.



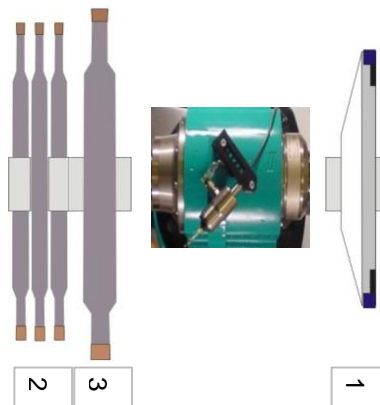
1. Cycletime for Production

Workpiece: Braided teeth Material HSS							
Operations							
	Probe	Face Plunge	OD Prgrd	Prf Plunge	PrfFlankPrgd	OD finish	PrfFlankFin
Feed [mm/Min]	2000	125	120	12	20	200	125
Power [kW]		2	2	4	4	1	1
Cutting speed [m/s]		32	32	26	26	28	28
Used wheels							
		1	1	2	2	3	3
Grinding time [s]	25	278	268	481	601	85	313
Total cycle time	34 Min 12						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	12C9 Ø250 B126
2	4x14A1,Ø200 B126
3	1A1 Ø300 B126



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NGM
Control: Fanuc 31iB 5
Accessories: ISO-50 hydraulic clamping
Responsible engineer: OP, 10.11.18

Coolant: Synthetic Oil, pressure 16 bar
Software: Qg1

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland
Subsidiaries in: France, Deutschland, Italia, United States, China